












Date: Wednesday, 18/06/2008 1:27:05 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 39927		
Estimate Number	: 13055		
P.O. Number	:	Part Number	: D36541
This Issue	: 18/06/2008 S.O. No. :	Drawing Number	: D3654 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 36915	Material	:
Written By	:	Due Date	: 07/07/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>50.08.6.18</u>		
Comment	: Est Rev:A New Issue 07-10-29 DD verified by: EC Est Rev:B ecn1162 08-04-02 DD verified by:		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
			
Comment: Qty.: 0.3675 sf(s)/Unit Total : 0.7350 sf(s) 304/316 SS sheet 16 ga (0.063" thick) Batch: <u>100090</u> <u>B 8-6-26</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3654 Dwg Rev: <u>A</u> <u>B 8-6-26</u> (3) Prog Rev: <u>A</u> 2-Deburr if necessary <u>B 8-6-26</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>S 08/07/01</u> (3)			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and stock Location: <u>GA</u> <u>S 08/07/01</u> (3)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 39927

Part Number: D36541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.07.08

**Dart Aerospace Ltd**

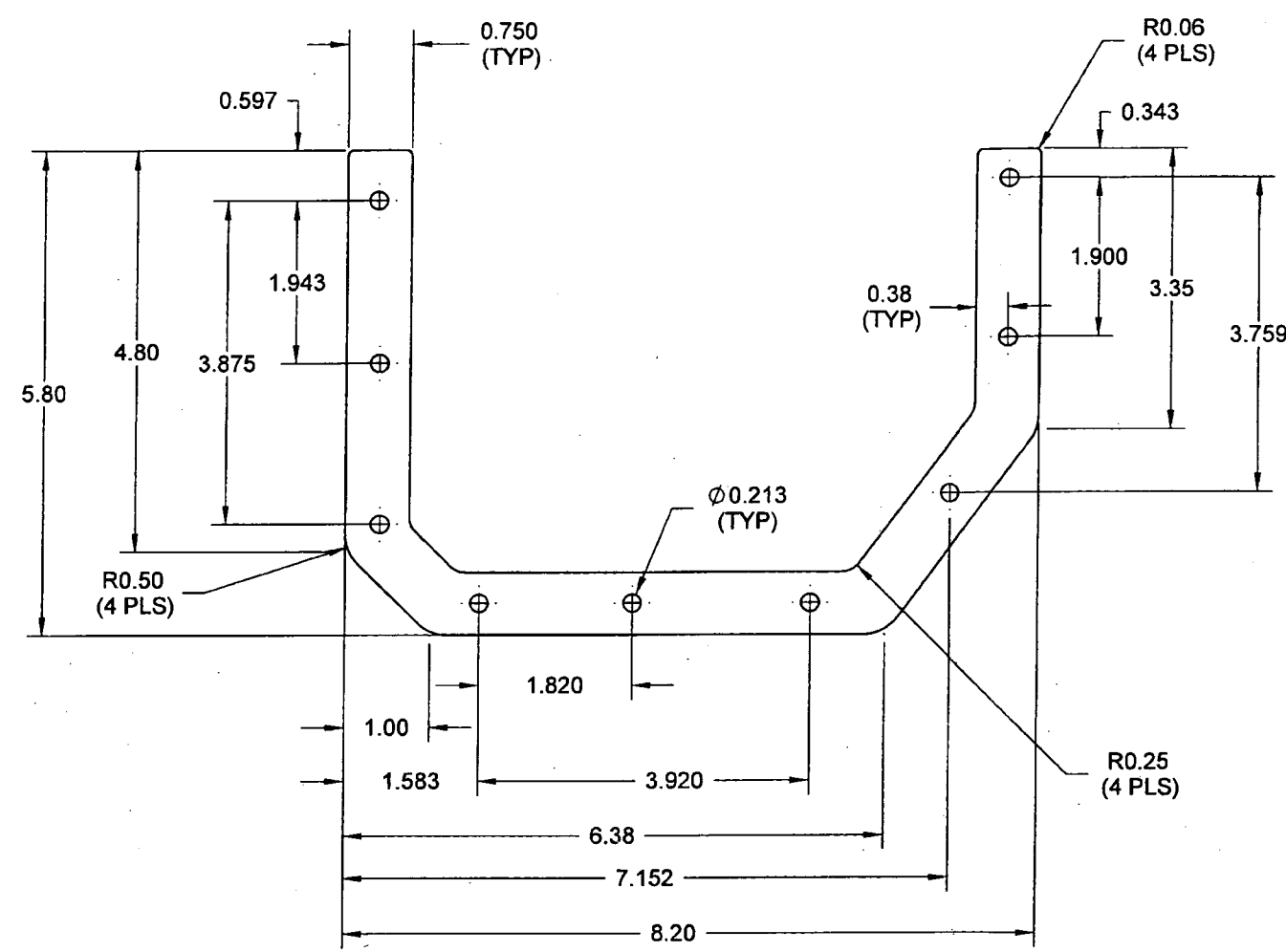
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3654-1 DOUBLER**

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.063 (16 GAUGE) SHEET PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3654-1 USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.03 lbs

A	NEW ISSUE	1	RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	RF	DRAWING NO.	REV. A	
MFG. APPR.	RF	D3654	SHEET 1 OF 1	
APPROVED	RF	TITLE	SCALE	
DE APPR.	RF	DOUBLER	1:2	
DATE	07.11.07		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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WITHOUT NOTICE  
WORK ORDER  
NO. 3021

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39927
<b>Description:</b> DouBLER		<b>Part Number:</b> D3654-1
<b>Inspection Dwg:</b> D3654-1 Rev: A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 2.13	±.005 - .001	2.14	X		✓	
.750	±.010	.752	X		✓	
1.943	±.010	1.943	X			
.597	±.010	.599	X			
3.875	±.010	3.875	X			
4.80	±.030	4.80	X			
5.80	±.030	5.80	X			
3.403	±.030	3.44	X			
1.900	±.010	1.901	X			
3.35	±.030	3.355	X			
3.759	±.010	3.759	X			
1.00	±.030	1.00	X			
1.583	±.010	1.583	X			
1.820	±.010	1.820	X			
3.920	±.010	3.920	X			
6.38	±.030	6.381	X			
7.15	±.010	7.154	X			
8.20	±.030	8.201	X			

<b>Measured by:</b> HB	<b>Audited by:</b> S	<b>Prototype Approval:</b> n
<b>Date:</b> 8-6-27	<b>Date:</b> 08/07/07	<b>Date:</b> 8

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	